

Date: Friday, 11/16/2007 7:20:58 AM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---|------------------|------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : SADDLE, OUTBOARD, LH, 206 |
| Job Number | : 35803 | | |
| Estimate Number | : 10818 | | |
| P.O. Number | : | Part Number | : D26651 |
| This Issue | : 11/16/2007 S.O. No. : | Drawing Number | : D2665 REV.D |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : 1/1 Type : MACHINED PARTS | Drawing Revision | : D |
| Previous Run | : 35046 | Material | : |
| Written By | : | Due Date | : 12/5/2007 Qty: 12 Um: Each |
| Checked & Approved By | : <u>07/11/16</u> | | |
| Comment | : Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC Est Rev:D As per Rev D 07-03-19 JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----------|-------------------------|
| 1.0 | D6101003 | 7075-T7351 2X6.25X7.875 |
|-----|----------|-------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
 7075-T7351 2X6.25X7.875
 Cut Size 2.0" x 6.25" x 7.88"
 Grain Along Long 7.88 Length Batch no B34873

08/02/06

| | | |
|-----|-------|--------------------------------|
| 2.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1

Program batch number.

1-Inspect part number and batch number are programmed correctly.

3-Fixturing inspection fast completed on _____ by _____

4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet

5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet

7- Deburr

08/02/07

08/02/06

| | | |
|-----|---------------|------------------------------|
| 3.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE |
|-----|---------------|------------------------------|



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

08/02/07

(12)

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

08/02/08

(12)

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: P Date: 08/02/15
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 11/16/2007 7:20:58 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, LH, 206

Job Number: 35803

Part Number: D26651

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 08/02/11 (12)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FX 08/02/11 (12)

7.0

POWDER COATING

POWDER COATING



M107005



(12x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-1 08/02/12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



22



Comment: INSPECT POWDER COAT

08-02-12 (41)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 436

8/20/13 SC (12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/02/15 (12)

Job Completion



Jim 2008/2/13 (12)

W

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|---|---------------------|--------------------|
| DART AEROSPACE LTD | Work Order: | 35803 |
| Description: 206 Saddle, Outboard, Left side | Part Number: | D2665-1 |
| Inspection Dwg: D2665 Rev. D | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

| | | | | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|--------|-------|--------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | | |
| A | 0.100 | 0.140 | | 0.130 | 0.130 | 0.129 | 0.1295 | | |
| B | 0.100 | 0.140 | | 0.133 | 0.133 | 0.133 | 0.133 | | |
| C | 1.125 | 1.145 | | 1.140 | 1.140 | 1.140 | 1.140 | | |
| D | 0.615 | 0.685 | | 0.670 | 0.670 | 0.670 | 0.670 | | |
| E | 0.240 | 0.260 | | 0.253 | 0.252 | 0.252 | 0.252 | | |
| F | 1.313 | 1.343 | | 1.321 | 1.321 | 1.321 | 1.321 | | |
| G | 0.210 | 0.230 | | 0.219 | 0.219 | 0.219 | 0.219 | | |
| H | 0.100 | 0.180 | | 0.145 | 0.145 | 0.145 | 0.145 | | |
| I | 2.470 | 2.510 | | 2.494 | 2.494 | 2.494 | 2.494 | | |
| J | 1.565 | 1.585 | | 1.580 | 1.580 | 1.580 | 1.580 | | |
| K | 0.235 | 0.240 | | 0.238 | 0.238 | 0.238 | 0.238 | | |
| L | 0.100 | 0.120 | | 0.115 | 0.116 | 0.116 | 0.116 | | |
| M | 0.990 | 1.010 | | 0.997 | 0.995 | 0.997 | 0.998 | | |
| N | 0.510 | 0.515 | | 0.511 | 0.511 | 0.511 | 0.511 | | |
| O | 5.990 | 6.010 | | 6.003 | 6.003 | 6.003 | 6.003 | | |
| P | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1.250 | | |
| Q | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| R | 0.313 | 0.318 | | 0.314 | 0.314 | 0.314 | 0.314 | | |
| S | 0.315 | 0.322 | | 0.3195 | 0.320 | 0.320 | 0.320 | | |
| T | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| U | 1.357 | 1.367 | | 1.3615 | 1.361 | 1.361 | 1.361 | | |
| V | 0.787 | 0.807 | | 0.797 | 0.797 | 0.797 | 0.797 | | |
| W | 0.540 | 0.560 | | 0.547 | 0.549 | 0.548 | 0.548 | | |
| X | 1.674 | 1.684 | | 1.679 | 1.679 | 1.679 | 1.679 | | |
| Y | 0.257 | 0.262 | | 0.259 | 0.259 | 0.259 | 0.259 | | |
| Z | 0.912 | 0.932 | | 0.9225 | 0.9225 | 0.923 | 0.923 | | |
| AA | 0.490 | 0.510 | | 0.500 | 0.500 | 0.500 | 0.500 | | |
| AB | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | | |
| AC | | | | | | | | | |
| AD | | | | | | | | | |
| AE | | | | | | | | | |
| AF | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

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|--------------|----------|
| Measured by: | DS |
| Date: | 08/02/07 |

| | |
|-------------|----------|
| Audited by: | SA |
| Date: | 08/02/11 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 99.04.19 | Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A | RF | |
| C | 99.11.10 | Added Dim. R-T | RF | |
| D | 02.12.12 | Reformat; Added Dim. U-W & DT8683, DT8686 | KJ/RF | |
| E | 06.07.05 | Revised per drawing revision C | KJ/JLM | |
| F | 07.03.21 | Revised per drawing revision D | KJ/JLM | |

| | |
|---|-----------------------------|
| DART AEROSPACE LTD | Work Order: 35803 |
| Description: 206 Saddle, Outboard, Left side | Part Number: D2665-1 |
| Inspection Dwg: D2665 Rev. D | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

| | | | | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|--------|--------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 5 | 6 | 7 | 8 | | |
| A | 0.100 | 0.140 | | 0.129 | 0.130 | 0.129 | 0.129 | | |
| B | 0.100 | 0.140 | | 0.133 | 0.133 | 0.133 | 0.134 | | |
| C | 1.125 | 1.145 | | 1.140 | 1.140 | 1.140 | 1.140 | | |
| D | 0.615 | 0.685 | | 0.670 | 0.670 | 0.670 | 0.670 | | |
| E | 0.240 | 0.260 | | 0.252 | 0.252 | 0.252 | 0.252 | | |
| F | 1.313 | 1.343 | | 1.321 | 1.321 | 1.321 | 1.321 | | |
| G | 0.210 | 0.230 | | 0.219 | 0.219 | 0.219 | 0.219 | | |
| H | 0.100 | 0.180 | | 0.142 | 0.140 | 0.140 | 0.140 | | |
| I | 2.470 | 2.510 | | 2.496 | 2.496 | 2.493 | 2.494 | | |
| J | 1.565 | 1.585 | | 1.580 | 1.580 | 1.580 | 1.580 | | |
| K | 0.235 | 0.240 | | 0.238 | 0.238 | 0.238 | 0.238 | | |
| L | 0.100 | 0.120 | | 0.116 | 0.116 | 0.116 | 0.116 | | |
| M | 0.990 | 1.010 | | 1.003 | 1.004 | 1.003 | 1.003 | | |
| N | 0.510 | 0.515 | | 0.511 | 0.511 | 0.511 | 0.511 | | |
| O | 5.990 | 6.010 | | 6.003 | 6.003 | 6.003 | 6.003 | | |
| P | 1.245 | 1.255 | | 1.2505 | 1.250 | 1.249 | 1.249 | | |
| Q | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| R | 0.313 | 0.318 | | 0.314 | 0.314 | 0.314 | 0.314 | | |
| S | 0.315 | 0.322 | | 0.320 | 0.320 | 0.320 | 0.320 | | |
| T | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| U | 1.357 | 1.367 | | 1.361 | 1.361 | 1.361 | 1.361 | | |
| V | 0.787 | 0.807 | | 0.797 | 0.797 | 0.796 | 0.796 | | |
| W | 0.540 | 0.560 | | 0.548 | 0.548 | 0.5485 | 0.5485 | | |
| X | 1.674 | 1.684 | | 1.679 | 1.679 | 1.679 | 1.679 | | |
| Y | 0.257 | 0.262 | | 0.259 | 0.259 | 0.259 | 0.259 | | |
| Z | 0.912 | 0.932 | | 0.922 | 0.922 | 0.923 | 0.922 | | |
| AA | 0.490 | 0.510 | | 0.500 | 0.500 | 0.500 | 0.500 | | |
| AB | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | | |
| AC | | | | | | | | | |
| AD | | | | | | | | | |
| AE | | | | | | | | | |
| AF | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

| |
|------------------------|
| Measured by: <i>DP</i> |
| Date: 08/02/08 |

| |
|-----------------------|
| Audited by: <i>SA</i> |
| Date: 08/02/08 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 99.04.19 | Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A | RF | |
| C | 99.11.10 | Added Dim. R-T | RF | |
| D | 02.12.12 | Reformat; Added Dim. U-W & DT8683, DT8686 | KJ/RF | |
| E | 06.07.05 | Revised per drawing revision C | KJ/JLM | |
| F | 07.03.21 | Revised per drawing revision D | KJ/JLM | |

| | |
|---|-----------------------------|
| DART AEROSPACE LTD | Work Order: 35803 |
| Description: 206 Saddle, Outboard, Left side | Part Number: D2665-1 |
| Inspection Dwg: D2665 Rev. D | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|----------------|----------------------------|--------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 9 | 10 | 11 | 12 | By | Date |
| A | 0.100 | 0.140 | | 0.131 | 0.130 | 0.130 | .130 | | |
| B | 0.100 | 0.140 | | 0.140 | 0.133 | 0.133 | .133 | | |
| C | 1.125 | 1.145 | | 1.140 | 1.140 | 1.140 | 1.140 | | |
| D | 0.615 | 0.685 | | 0.670 | 0.670 | 0.670 | .670 | | |
| E | 0.240 | 0.260 | | 0.252 | 0.252 | 0.252 | .252 | | |
| F | 1.313 | 1.343 | | 1.321 | 1.321 | 1.321 | 1.321 | | |
| G | 0.210 | 0.230 | | 0.219 | 0.218 | 0.219 | .219 | | |
| H | 0.100 | 0.180 | | 0.140 | 0.140 | 0.140 | .140 | | |
| I | 2.470 | 2.510 | | 2.496 | 2.494 | 2.493 | 2.493 | | |
| J | 1.565 | 1.585 | | 1.580 | 1.580 | 1.580 | 1.580 | | |
| K | 0.235 | 0.240 | | 0.238 | 0.238 | 0.238 | .238 | | |
| L | 0.100 | 0.120 | | 0.116 | 0.116 | 0.116 | .116 | | |
| M | 0.990 | 1.010 | | 1.003 | 1.004 | 1.003 | 1.003 | | |
| N | 0.510 | 0.515 | | 0.511 | 0.511 | 0.511 | .511 | | |
| O | 5.990 | 6.010 | | 6.003 | 6.003 | 6.002 | 6.002 | | |
| P | 1.245 | 1.255 | | 1.260 | 1.25 | 1.250 | 1.250 | | |
| Q | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| R | 0.313 | 0.318 | | 0.314 | 0.314 | 0.314 | .314 | | |
| S | 0.315 | 0.322 | | 0.320 | 0.320 | 0.320 | 0.320 | | |
| T | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| U | 1.357 | 1.367 | | 1.361 | 1.3615 | 1.361 | 1.360 | | |
| V | 0.787 | 0.807 | | 0.797 | 0.7965 | 0.796 | .795 | | |
| W | 0.540 | 0.560 | | 0.548 | 0.547 | 0.548 | .548 | | |
| X | 1.674 | 1.684 | | 1.679 | 1.679 | 1.679 | 1.679 | | |
| Y | 0.257 | 0.262 | | 0.259 | 0.259 | 0.259 | 0.259 | | |
| Z | 0.912 | 0.932 | | 0.922 | 0.922 | 0.922 | .922 | | |
| AA | 0.490 | 0.510 | | 0.502 | 0.501 | 0.501 | .500 | | |
| AB | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | .188 | | |
| AC | | | | | | | | | |
| AD | | | | | | | | | |
| AE | | | | | | | | | |
| AF | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

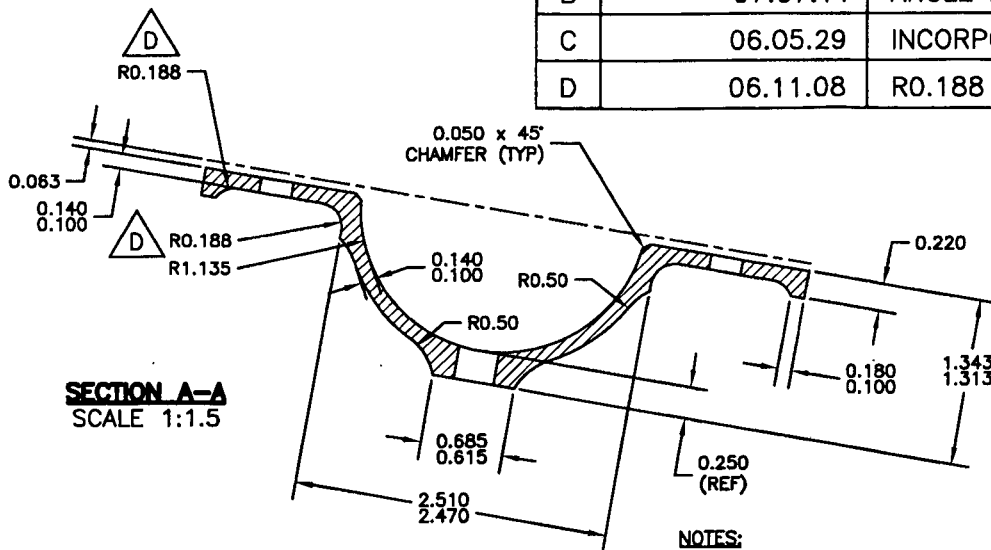
| | |
|------------------|----------------|
| Measured by: DTP | Audited by: SD |
| Date: 08/07/08 | Date: 08/02/11 |

| | |
|------------------|----------------|
| Measured by: DTP | Audited by: SD |
| Date: 08/07/08 | Date: 08/02/11 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 99.04.19 | Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A | RF | |
| C | 99.11.10 | Added Dim. R-T | RF | |
| D | 02.12.12 | Reformat; Added Dim. U-W & DT8683, DT8686 | KJ/RF | |
| E | 06.07.05 | Revised per drawing revision C | KJ/JLM | |
| F | 07.03.21 | Revised per drawing revision D | KJ/JLM | |

DART

| | | | |
|------------------|----------------------------------|--|------------------------|
| DESIGN # | DRAWN BY CB | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED PH | APPROVED # | DRAWING NO. D2665 | REV. D SHEET 1 OF 1 |
| DATE 06.11.08 | TITLE SADDLE FWD OUTSIDE HIGH | | SCALE 1:3 |
| A | 97.03.25 | NEW ISSUE | |
| B | 97.07.11 | ANGLE AND NOTES ADDED | |
| C | 06.05.29 | INCORPORATE DEO 9122, 9102, 9095 | |
| D | 06.11.08 | R0.188 WAS R0.30; Ø0.316 WAS Ø0.313 | |

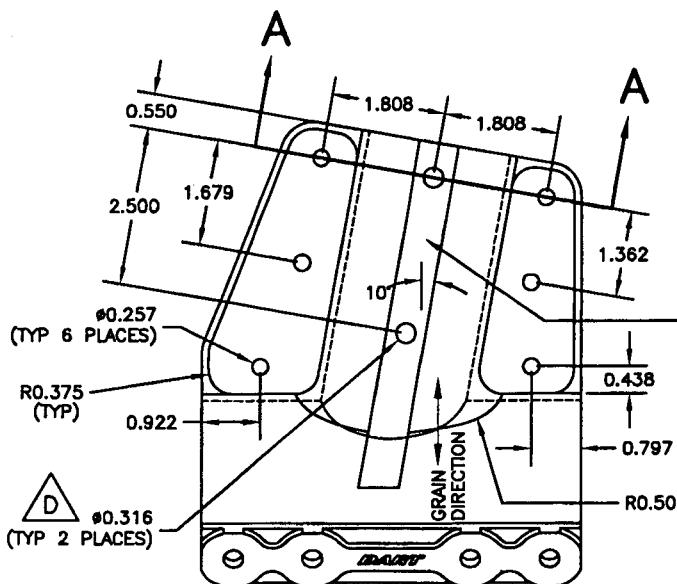


RELEASED

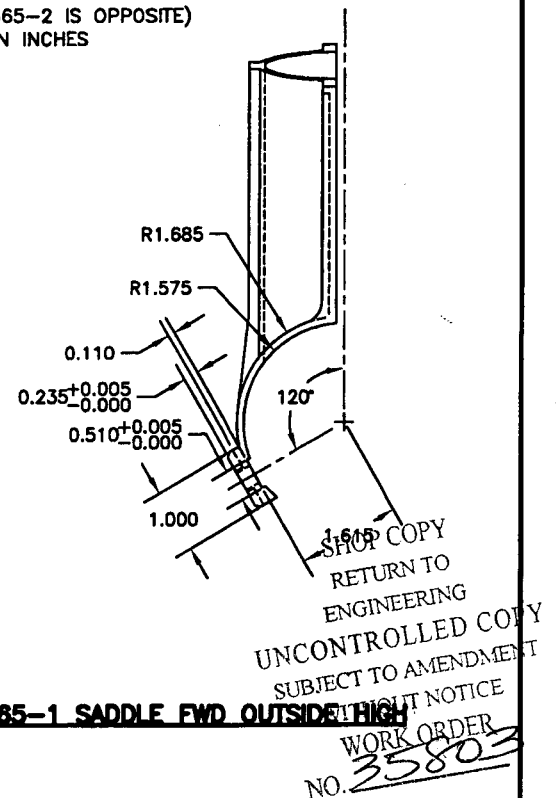
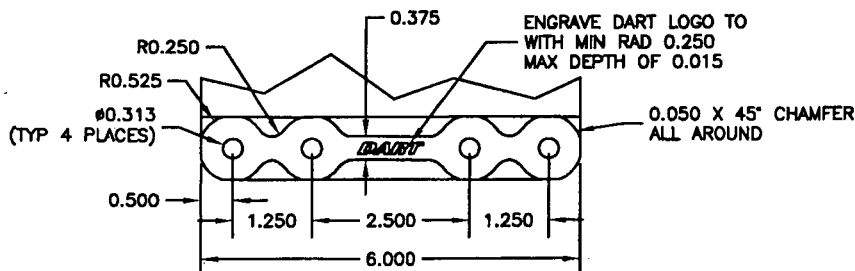
07.02.12 #

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010

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